

Work Order ID 80335

80335

Page 1

February-17-12 8:29:56 AM

Item ID: D3536-35

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 17/02/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 02/03/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/02/12 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3536	Rev A
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100	FLOW WATER JET	0.00
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Debur if necessary

B12-3-4



110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Memo

0.00

Quality Control

B12-3-4

120	QC8- Inspect parts - second check	0.00
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120

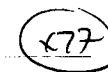
QC

Memo

0.00

Quality Control

Sizel/5



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80335***80335***

Page 2

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Revision ID:

Stop ***NS2***

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24

Cust Item ID:

Required Date: 02/03/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:


Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location 

0.00

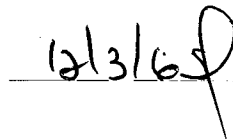
130

Packaging

Memo

0.00

Packaging

 12/3/6 270

140

QC21- Final Inspection - Work Order Release

0.00

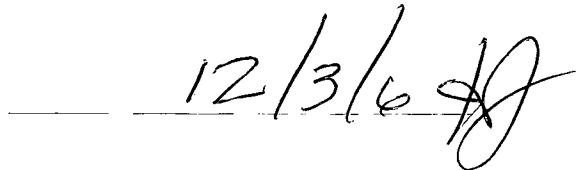
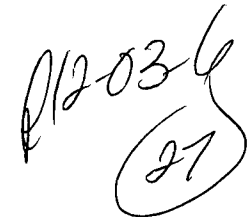
140

QC

Memo

0.00

Quality Control

 12/3/6 02-03-6
(27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-17-12 8:29:59 AM

Page 1

Work Order ID: 80335

80335

Parent Item: D3536-35

D3536-35

Parent Item Name: Gasket

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	208.0000	0.6197	16.52533	18.		

MNEO60S 063

NEOPRENE SHEET 0.063

**

1812-3-4

Location

Loc Qty

Loc Code

MAT052

208

119130

3

119777

34.5

119792

170.5

149792

27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80335
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.28	2		T B01	
19.75	+/-0.030	19.75	2		T	
17.75	+/-0.030	17.75	7		T	
14.25	+/-0.030	14.28	2		T	
9.50	+/-0.030	9.50	4		T	
4.75	+/-0.030	4.75	7		T	
2.00	+/-0.030	2.00	2		T	
6.00	+/-0.030	6.00	7		T	
6.75	+/-0.030	6.75	1		T	
0.30	+/-0.030	0.306	8		V B02	
0.30	+/-0.030	0.303	1		V	
1.89	+/-0.030	1.884	2		V	
Ø0.19	+0.005/-0.001	0.193	2		V	
0.063	+/-0.010	0.058	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-3-14	Date: 12/3/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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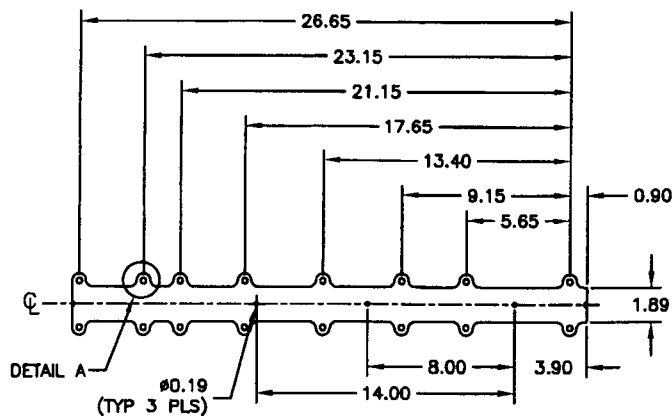
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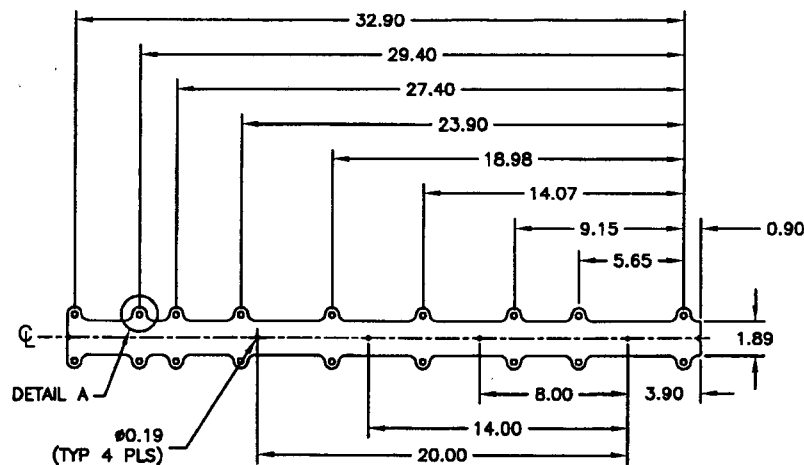
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CHECKED RH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED
09.02.12-11

STG
REQ
DATE
UNCOND
SUB
W.D.
V.D.
NO. 80335 M.C.J
12/02/17



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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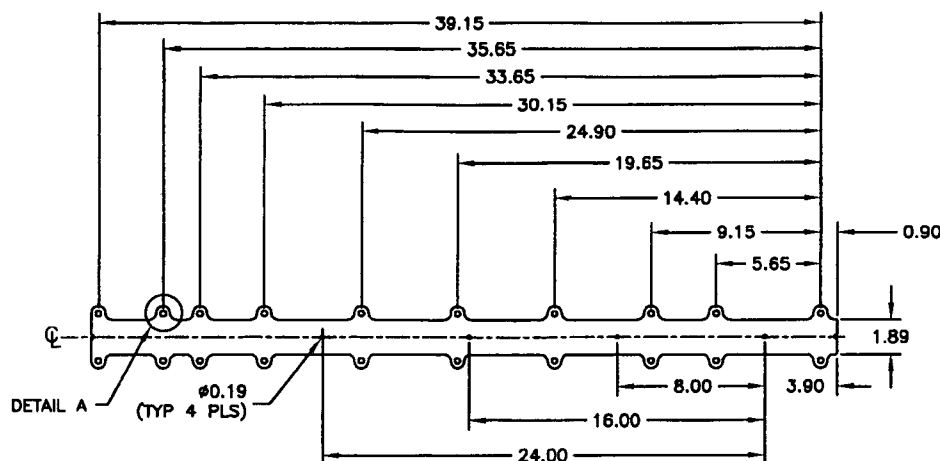
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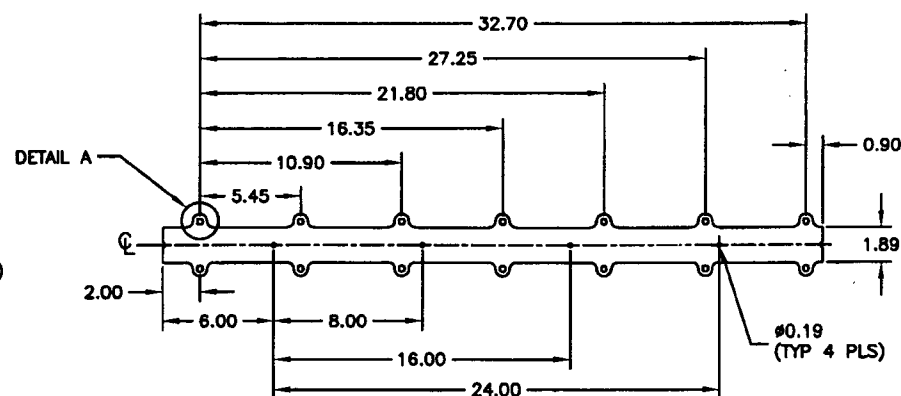
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 2 OF 6
				SCALE 1:10

80335

RELEASED
070212



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

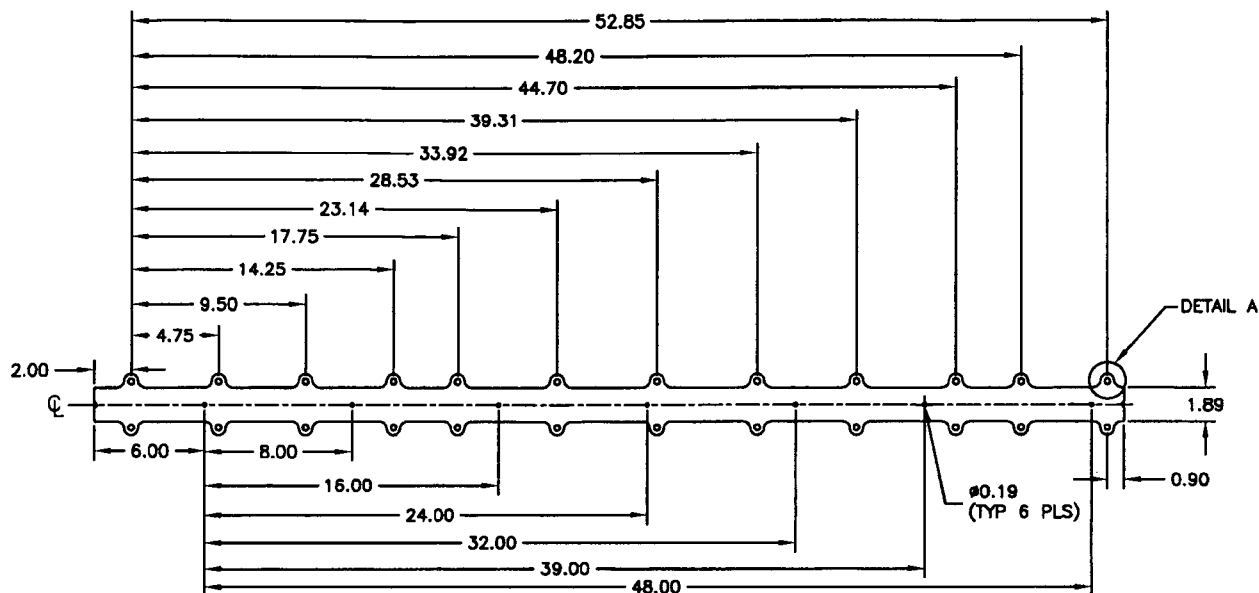
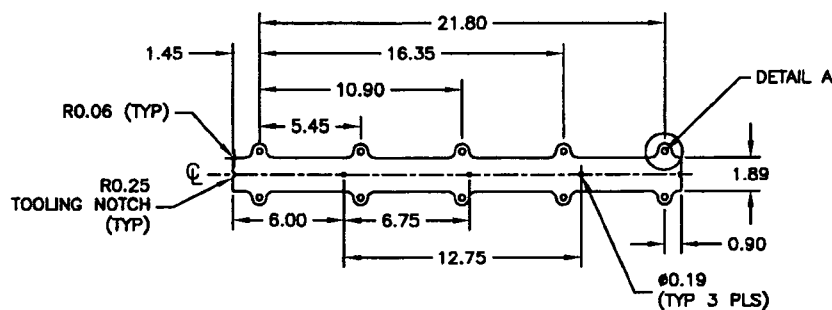
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 3 OF 6	
	SCALE 1:10		

80335

RELEASED
07.02.12**D3536-23 GASKET****D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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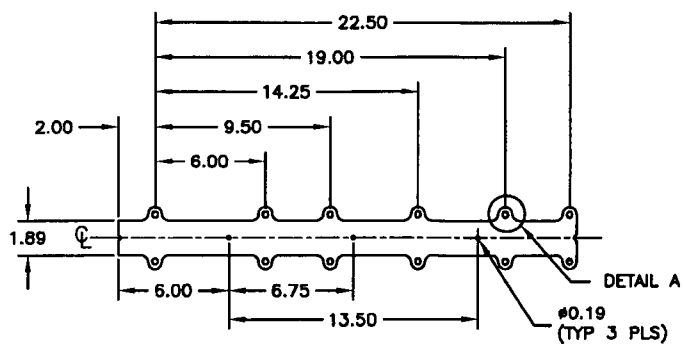
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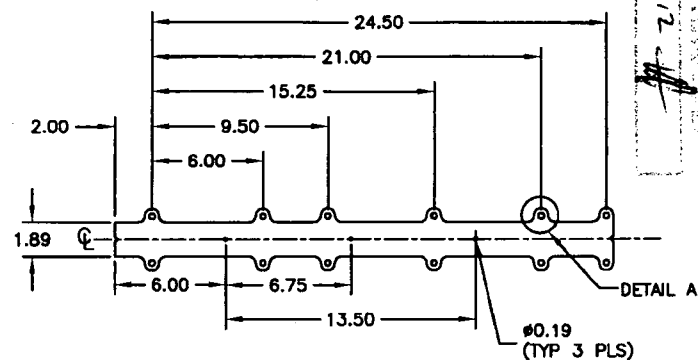
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CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
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DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 4 OF 6
		SCALE
		1:10

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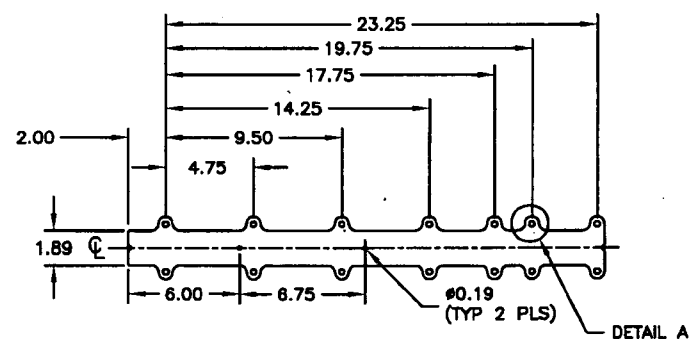
07.03.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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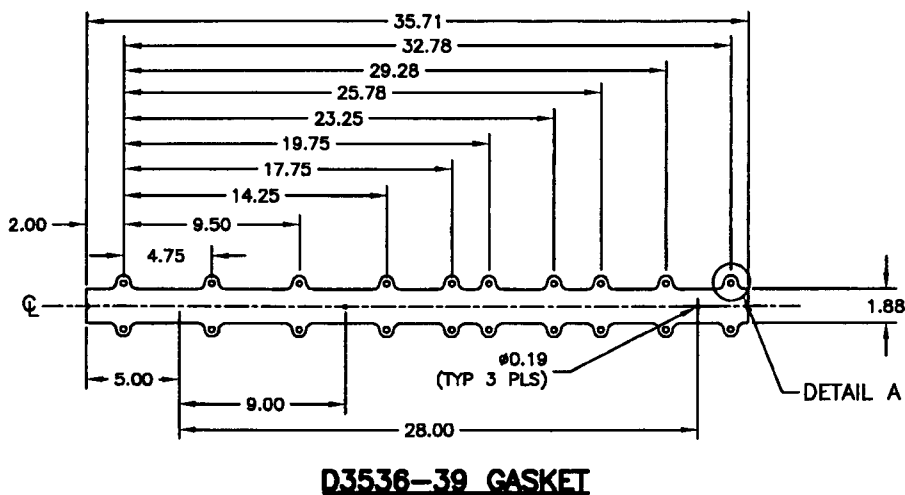
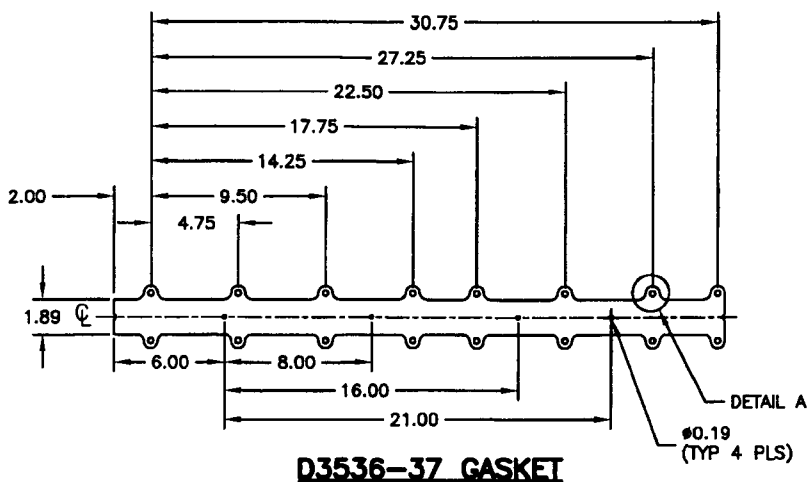
NOTE: Date & initial all entries

DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	GASKET
REV. A		SHEET 5 OF 6		
SCALE	1:10			

80335

07.02.12



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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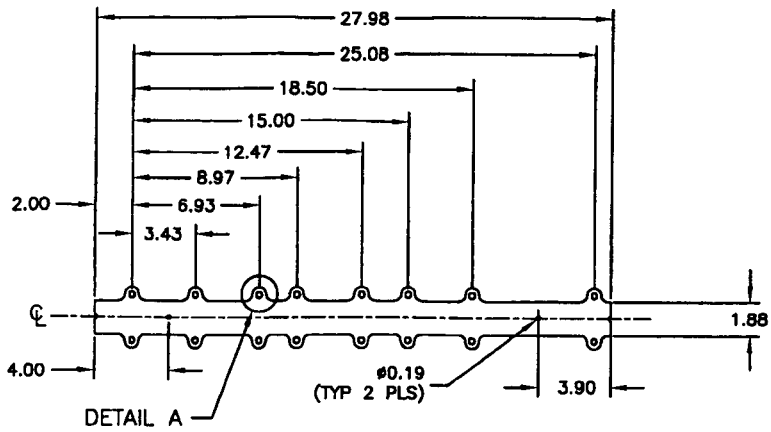
NOTE: Date & initial all entries



DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
				SHEET 6 OF 6
				SCALE 1:10

80335

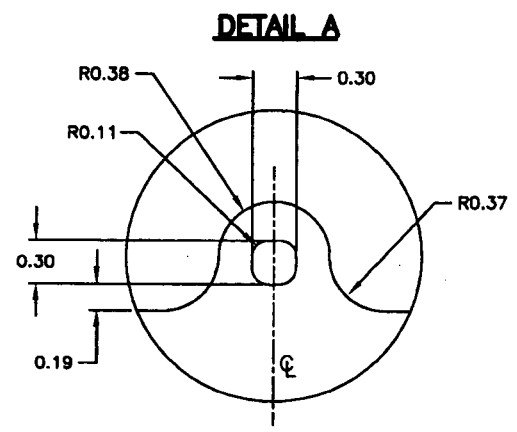
07.02.12



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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